

Date: Thursday, 9/14/2006 7:28:42 AM
 User: Kim Johnston

Process Sheet

| | |
|---|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : VALVE SEAL |
| Job Number : 28558 | |
| Estimate Number : 12207 | |
| P.O. Number : <i>N/A</i> | Part Number : D34707 |
| This Issue : 9/14/2006 S.O. No. : <i>N/A</i> | Drawing Number : D3470 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <i>N/A</i> Type : SMALL / MED FAB | Drawing Revision : A |
| Previous Run : 26988 | Material : <i>N/A</i> |
| Written By : <i>[Signature]</i> | Due Date : 10/6/2006 Qty: 4 Um: Each |
| Checked & Approved By : <i>[Signature]</i> | |
| Comment : Est Rev: A New Issue 06-04.20 EC | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|---|--------------------------------|
| 1.0 | MSIL603125 <i>MSIL605063</i> | high temp. silicone sheet .125 |
|-----|---|--------------------------------|

*D3255 gasket*

Comment: Qty.: 0.0648 sf(s)/Unit Total: 0.2591 sf(s)

Material: *.125"* Thick High Temp Silicone sheet*(MSIL603125) (MSIL605063) B26473*Batch: *[Signature]*

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

Cut as per Dwg D

Dwg Rev: *A*Prog Rev: *A**[Signature] 06/10/02**(4)*

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*[Signature] 06/10/02**(4)*

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

[Signature] 06-10-03 (4)

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57441**[Signature] 06/10/03**(4)*

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 06/10/05
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 7:28:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VALVE SEAL

Job Number: 28558

Part Number: D34707

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

09/10/05

Job Completion



U 86-10-05

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

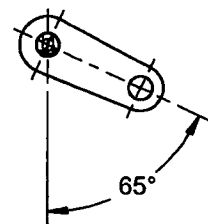
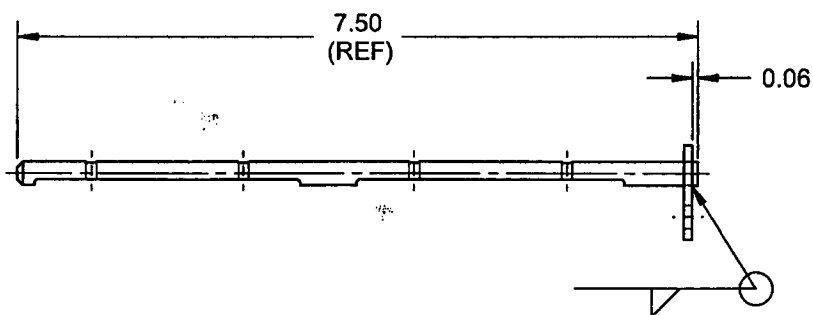
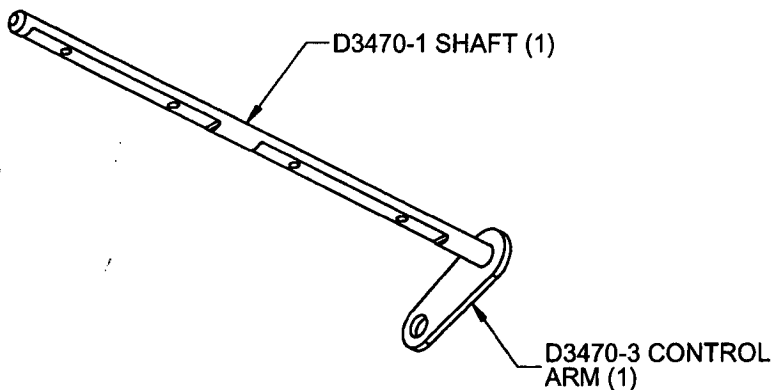
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|--|------------------------|
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3470 | REV. A SHEET 1 OF 4 |
| DATE 05.12.14 | | TITLE SHUT-OFF VALVE SHAFT | SCALE 1:2 |
| A | 05.12.14 | NEW ISSUE | |



D3470-041 SHUT-OFF VALVE SHAFT

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0604.03 SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 28558

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

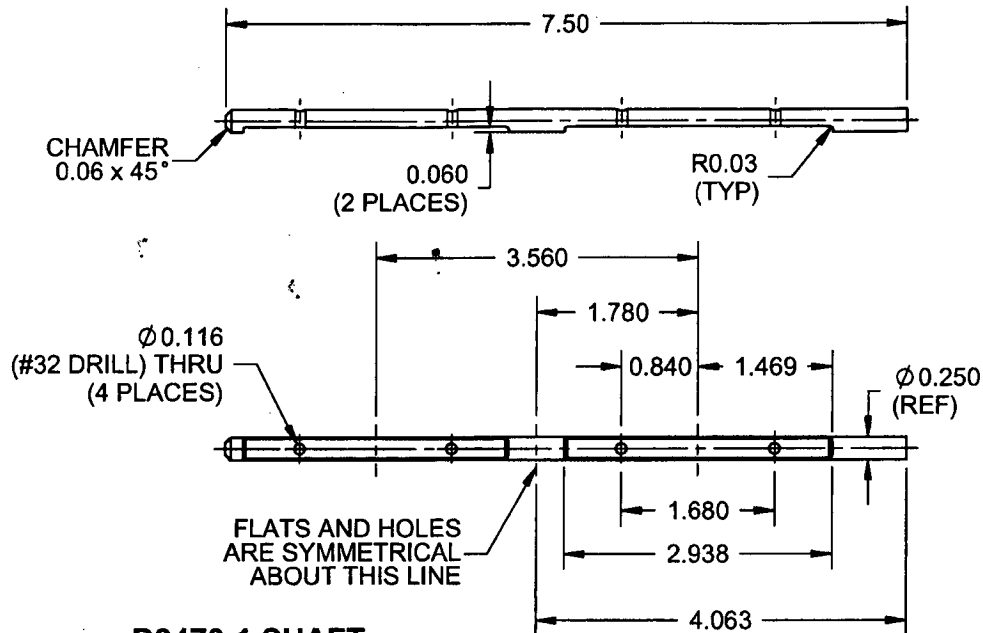
| QTY -041 | P/N | DESCRIPTION |
|-------------|-----------|----------------------|
| X | D3470-041 | SHUT-OFF VALVE SHAFT |
| 1 | D3470-1 | SHAFT |
| 1 | D3470-3 | CONTROL ARM |

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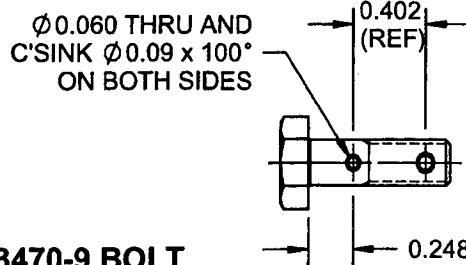
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3470 | REV. A SHEET 2 OF 4 |
| DATE 05.12.14 | | TITLE SHUT-OFF VALVE SHAFT | SCALE 1:2 |

**D3470-1 SHAFT**

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR
(REF. DART SPEC. M303R0.250)

**D3470-9 BOLT**

SCALE 1:1

- 1) MAKE FROM AN4-6 BOLT

NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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06-04-03
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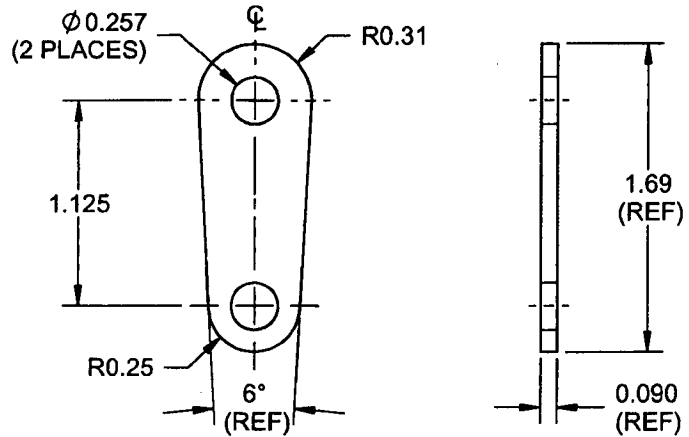
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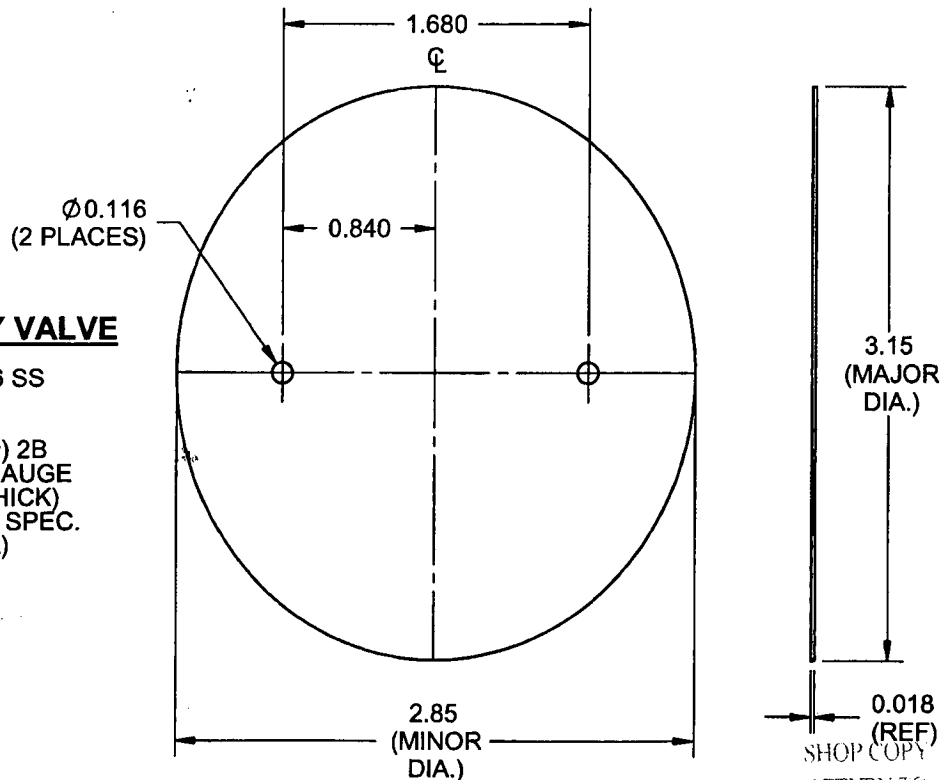
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3470 | REV. A SHEET 3 OF 4 |
| DATE 05.12.14 | | TITLE SHUT-OFF VALVE SHAFT | SCALE 1:1 |

D3470-3 CONTROL ARM

- 1) MATERIAL: AISI 304/316 SS SHEET PER
MIL-S-5019 (ANNEALED) 2B
FINISH 13 GAUGE SS
(0.090 THICK)
(REF. DART SPEC. M304S13GA)

**D3470-5 BUTTERFLY VALVE**

- 1) MATERIAL: AISI 304/316 SS
SHEET PER
MIL-S-5019
(ANNEALED) 2B
FINISH 26 GAUGE
SS (0.018 THICK)
(REF. DART SPEC.
M304S26GA)

**NOTES:**

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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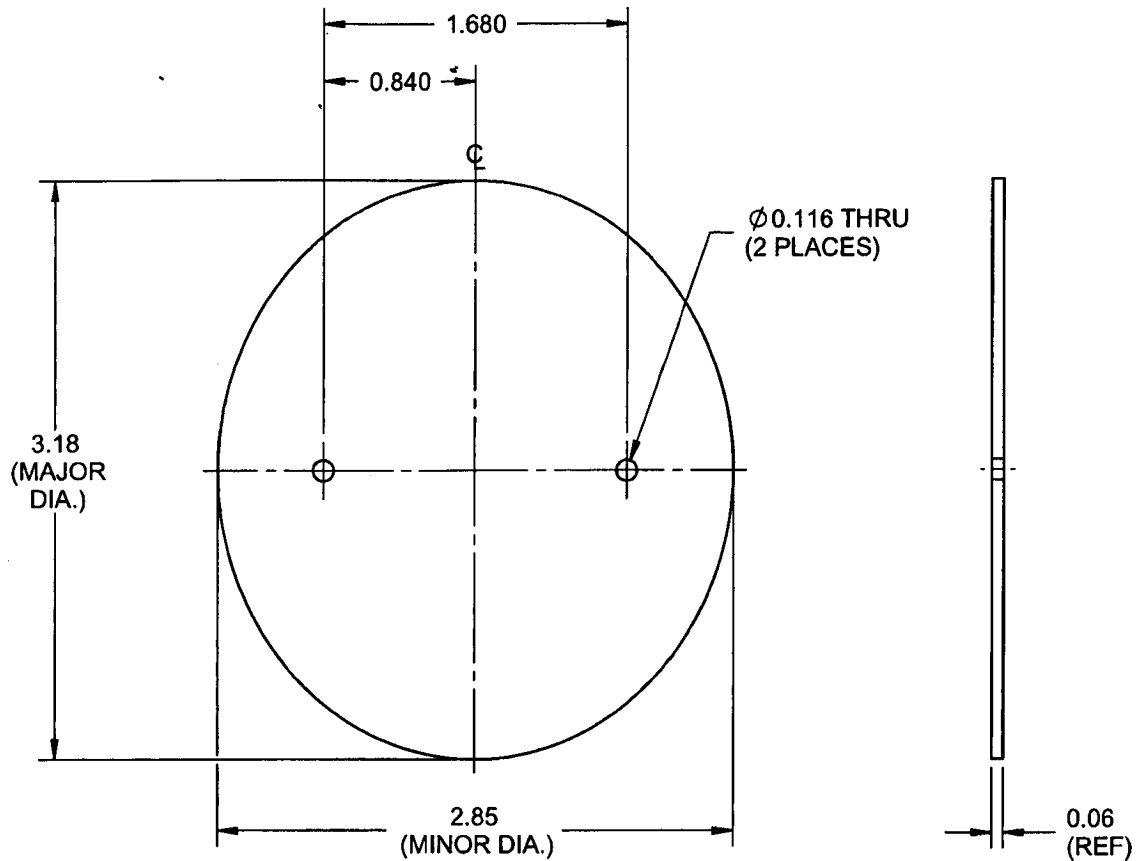
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3470 | REV. A SHEET 4 OF 4 |
| DATE 05.12.14 | | TITLE SHUT-OFF VALVE SHAFT | SCALE 1:1 |

**D3470-7 BUTTERFLY VALVE SEAL****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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